

Work Order ID 69657

Monday, May 16, 2011 8:56:23 AM



Page 1

Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: Date: 11-05-14Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

11 06 29 (1)
for CL 11-6-16

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/6/17

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

11 06 29 (1)

B69666

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69657

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Page 2

Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Packaging	0.00							
	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311 Location: _____ PPP Rev: <u>F</u>								
140 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

CL 11/06/29 ①

11/6/30
ME 11-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 1

Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
 IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
 IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
 as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

1

Replacement Skidtube

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

Manufactured

No

110

Each

10.0000

1

1

GHW Modification

Location

Loc Qty

Loc Code

FG120

10

67596

6

68347

4

ATTN: D3414-041 - BLUE

D2932-1

Manufactured

No

110

Each

4.0000

1

1

Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST421

2

67259

2

ST428

2

67790

2

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 69657

Parent Item: D206-642-311BL



Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

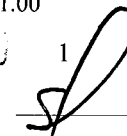
 D2933-1

X) Saddle LH In, 206

Manufactured No

110 Each

4.0000





Location

Loc Qty

Loc Code


ST421

4

67260

4



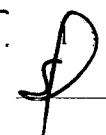
BLUE
D2938-1

X) Saddle LH Out, 206

Manufactured No

110 Each

4.0000





Location

Loc Qty

Loc Code


ST421

4

67261

4



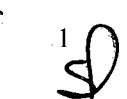
BLUE
D2939-1

X) Saddle LH In, 206

Manufactured No

110 Each

5.0000





Location

Loc Qty

Loc Code

ST421

3

67262

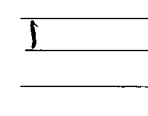
3

ST428A

2

67674

2



BLUE
AN3-41A

X) Bolt

Purchased No

110 Each

273.0000





Location

Loc Qty

Loc Code

ST354

273

112431

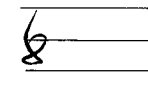
1

115936

72

116191

200



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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

224.0000

16 16

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

180

67756

180

Purchased No

110 Each

2,253.000

8 8

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

2253

116391

11

116540

276

116549

766

117441

800

117601

400

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000

8 8

Washer

AN5-10A

Purchased No

110 Each

180.0000

4 4

Bolt

Location

Loc Qty

Loc Code

ST337

180

117313

180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN5:11A
Bolt

Purchased No

110 Each

92.0000

Location

Loc Qty

Loc Code

ST337

92

117313

92

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

Washer

AN4-6A

Purchased

No

110

Each

1,153.000

Location

Loc Qty

Loc Code

ST356

953

115936

153

116400

400

116924

400

ST358

200

117514

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

Washer

MS21042L4

Purchased

No

110

Each

4,957.000

Location

Loc Qty

Loc Code

ST300

4957

114718

2

116823

1155

117441

3000

117601

800

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

19.0000



Tow Ring



[Handwritten signature]

69662

Location

Loc Qty

Loc Code

ST420

2

66386

2

ST464

17

64071

7

68339

10

A

BLUE

D3456-11

Manufactured No

110 Each

73.0000



Washer



B69774

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

66

66848

6

68748

60

D3457-11

Manufactured No

110 Each

40.0000



Washer



416178

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

30

67779

30

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 6

Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,304.000



Nut



1
sl

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

664

116188

-12

116549

176

117601

500

1

AN4CSA

Purchased

No

110

Each

530.0000



BOLT



1
sl

Location

Loc Qty

Loc Code

FP-B

115

112243

115

ST345

415

112243

415

1

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000



washer



1
1117735 11/6/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 7

Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Ring

Manufactured No

110 Each

34.0000

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

15

65294

1

66945

14

BLUE

D2712

Set Screw

Manufactured No

110 Each

451.0000

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

D2934

Saddle Spacer

Manufactured No

110 Each

38.0000

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 8

Work Order ID: 69657

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

56.0000

2

2



Saddle Spacer



11/6/17 SP

Location

Loc Qty

Loc Code

ST027

56

66564

56

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N
Date: 09.09.09